<b>Work Ord</b> November-27-12				*937	35*							Page 1
Item ID: Revision ID: Item Name: Start Date:	D3898-1 Floor Protecto	or (206L)  Start Qty: 2.00	*2*	Accept	*N900		100	)*	Setup	Start Stop	14.	S1* S2*
Required Date:		Req'd Qty: 2.00	*2*		Customer:							
Reference:									_	<b>6</b>		
Approvals:	Process Pl	an: MCJ	Date: 12-11-	Z7Tooling:	D	ate:			Run	Start	*NI	R1*
	QC:		Date:	SPC (Y/N):	D	ate:	· · · — —			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr										
D3898	Re	v A										
100				0.00								DAS
*100* HandThermo Hand Finishing The	ermoforming	<b>Memo</b> 1-Cut Sheet	to required Blank size	0.00								13/01/22
105		Dry material		0.00								DAS
*105* HandThermo		-		0.00					<del>-</del>			89
Hand Finishing Th	ermoforming	Temp:	340°F 7:00 pm 7:00 am									13/01/20

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	<b>NFOR</b>	MANCE / UP	DATE			
_											QA Closed:	Date:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac	-					Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	]		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	]	1	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	No.				<del></del>	Work Order Update	]		Large Fab	Composite		Supplier	
Root					Descri	tion of work order update	Ι.	L Initial	Δι	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	1	nief Eng		cription	Date	Verification	QC Inspector
Doc/Data	П						1						·
Equip/Tooling	П												
Operator			l										
Material	Ш		ļ										
Setup	Ш												
Other	Ц		1									·	
Process	Ш												
Supplier	Ш		1										
Training	Ш		1										
Unapproved													
						F	AUI	LT CATE	GCIRY				
Landi	ng G	Gear				General		_			_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
1		Centre No	ot Conce	ntric to (	)/s [	ROM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved
Positioned Wrong

Part Lost/Missing

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Complete FAI document

Memo

150

QC

Quality Control

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFORM	MANCE / UF		QA Closed:	Date:	
Work Order:		<u>.</u>			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material	ļ				•		1				•
Setup	]										
Other ``											
Process											
Supplier											
Training										}	

**Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Weld Cracks Broken/Damaged Inspection Incomplete Part Incorrect Wrong Stock Pulled Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Mislabeled Positioned Wrong Heat Treat Countersink Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Outside Dimensions Wave/Twist in Tube

**FAULT CATEGORY** 

Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 93735 Page 3 November-27-12 10:46:49 AM Setup Start Item ID: D3898-1 Accept \*N900040100\* **Revision ID:** Floor Protector (206L) Item Name: 11/19/12 Start Qty: 2.00 **Start Date: Cust Item ID: Req'd Qty: 2.00** Required Date: 12/07/12 **Customer:** Reference: Run Tooling: Process Plan: Date: Date: Approvals: Stop QC: \_\_\_\_\_ Date: SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan Accept Reject Reject Insp. Operation Set Up/ **Work Center ID** Code Qty Oty Number Stamp **Description Run Hours** QC5- Inspect part completeness to step on W/O 160 \*160\* QC Memo Quality Control Identify as per dwg & Stock Location: 0.00 170 \*170\* Memo PP096 510 194/2/2 Packaging Packaging 180 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

\*120\*

**Quality Control** 

QC

1/12013

NCR:	Yes	/ No				<b>WORK ORDER NON-</b> 0	100	NFORM	MANCE / UPDATE				
		<u></u>				_					QA Closed:	. Date:	
Work Ord	er:					DISPOSITION			AGA	AINST DE	PARTMENT	/PROCESS	
Part   NCR	No.					Rework Scrap Use-as-is Work Order Update		Therm	Machining Sma noforming Fini	stube II Fab shing oosite	ł	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			i		Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								••					
							AUL	T CATE	GORY				
Landi					_	General		1			1	Γ	7
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped <sub>.</sub>		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink		1 .	on Incomplete ions Incomplete/Unclear enance		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
1		Ripples in	Bend		1	Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Picklist Print** 

November-27-12 10:46:49 AM

Work Order ID:

93735

Parent Item:

D3898-1

Parent Item Name:

Floor Protector (206L)

Start Date: 11/19/12

Required Date: 12/07/12

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev.A New Issue 09/02/06 DL

IPP RevB Add Step 105 Dry Material

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	, Date Issued	Status
MLEXS.118-90318-08	,,	Purchased	No			100	sf	753.4949	10.6	22.315789			
Lexan Sheet				Location		Loc Oty	Lo	c Code	SEPTEMBER STATE OF ALL				3/0//2

**Location** therm

113127

753.4949406 753.494941

22.316 Sq ft.

NCR: Y	es / No				<b>WORK ORDER NON-</b>	CON	NFORM	MANCE / UPI	DATE			
										QA Closed:	Date	<u>;</u>
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	lo.				Rework Scrap Use-as-is		!	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	lo	-			Work Order Update	]		Large Fab	Composite	]	Supplier	
Root				Descri	ption of work order update	Ī	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		}										
Operator		1										
Material		1									i	
Setup												
Other												
Process												·
Supplier												
Training						1						
Unapproved		<u> </u>								<u> </u>	•	
						AUL	T CATE	GORY				
Landir	ng Gear				General	_	ı			7	-	_
	Bending			<u> </u>	Bend		Grain			Ovalized	1	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged			on Incomplete		Part Incorre	<b>-</b>	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			L	Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	elecl		Positioned V		
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	4		Power Loss/	Surge	Other
	Ripples ir	n Bend		L	Drill Holes		Offset					
	Torque V	Vaves in E	Extrusio	n	Drawing		Out of 0	Calibration				•

Out of Sequence

Outside Dimensions

DQA:

Date: \_\_\_

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

ART AEROSPA	CE LTD			Wo	rk Order:	93735
Description: Floor P	rotector			Pa	rt Number:	D3898-1
nspection Dwg: D3	898 <b>Rev</b> : A					Page 1 of 1
	FIRST A	RTICLE INSF	PECTION	CHECK	LIST	
	x	First Article		Prototy		
	T	HERMOFORM	WING SE	CTION		
Description			Accept	Reject	Method of Inspection	Comments
Inside Radii less thar	1 <u>N/A</u> "					
Shape Definition	•					
Texture Retention						
Material imperfection scratching	s such as bumps,	cracks, voids,	-			
						1 .
			7			T
Measured by:	$\mathcal{S}$				Date:	13/01/22
Measured by:	wh.	TOIMMING	SECTIO	NA I	Date:	13/01/22
	Dh.	TRIMMING	SECTIO	<b>DN</b>		13/01/22
Measured by:  Drawing  Dimension	Tolerance	TRIMMING Actual Dimension	S SECTION Accept	ON Reject	Date:	Comments
Drawing	Tolerance	Actual Dimension			Method of	
Drawing Dimension		Actual Dimension			Method of	
Drawing Dimension 0.50	Min	Actual Dimension  6.55" 1.01" 5.6"			Method of	
Drawing  Dimension  0.50  1.00  5.6  0.080	Min Min +0.2/-0.0 Min	Actual Dimension 6.55" 1.01" 5.6" 6.085"			Method of	
Drawing Dimension 0.50 1.00 5.6	Min Min +0.2/-0.0	Actual Dimension  6.55" 1.01" 5.6"			Method of	
Drawing Dimension 0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension 6.55" 1.01" 5.6" 6.085"	Accept		Method of	
Drawing Dimension 0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension 6.55" 1.01" 5.6" 6.085"	Accept		Method of	
Drawing Dimension 0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension 6.55" 1.01" 5.6" 6.085"	Accept		Method of	
Drawing Dimension 0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension 6.55" 1.01" 5.6" 6.085"	Accept		Method of	Comments
Drawing Dimension 0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension 6.55" 1.01" 5.6" 6.085"	Accept		Method of	Comments
Drawing Dimension 0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension 6.55" 1.01" 5.6" 6.085"	Accept		Method of	Comments
Drawing Dimension  0.50  1.00  5.6  0.080  0.050	Min +0.2/-0.0 Min Min	Actual Dimension 6.55" 1.01" 5.6" 6.085"	Accept		Method of	Comments
Drawing Dimension 0.50 1.00 5.6 0.080	Min +0.2/-0.0 Min Min  Min  15	Actual Dimension 6.55" 1.01" 5.6" 6.085"	Accept		Method of Inspection	Comments
Drawing Dimension  0.50  1.00  5.6  0.080  0.050  Measured by Audited by	Min +0.2/-0.0 Min Min  Min  115	Actual Dimension  6.55"  1.01"  5.6"  6.085"  0.077"	Accept		Method of Inspection	Comments  (2/01/2-3
Drawing Dimension  0.50  1.00  5.6  0.080  0.050  Measured by Audited by	Min +0.2/-0.0 Min Min  Min  115	Actual Dimension  6.55"  1.01"  5.6"  6.085"  0.077"	Accept		Method of Inspection  Date:	(3/01/23 /3~1.03 N/A

D3898-1 FLOOR PROTECTOR (206L)

 $\cap PY$ 1 3 75 - TEMNG TOTAL STED COPY - PROMENT COLUMN TICE 93735\_MLT 12-11-27

С

NOTES:
1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS
7) WEIGHT: 5.0 Ibs.
8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

D

A NEW ISSUE PH 09.02.27 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3898 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE DE APPR. NTS DATE 09.02.27

3

8

5

